

**Work Order ID 60922**

Monday, July 26, 2010 3:47:46 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 7/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: MDate: 10-7-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG002

N/A

110

0.00



CNC Bend 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

IX MB 10-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

AWM  
10-08-23

1 - JE 10-08-23

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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004  
A/R□□□ Aluminum Rod

M114877

BE 10/08/23

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill  
A/R□□□ Aluminum Rod

M114877

BE 10/08/23

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",  
adjust stopper not to hit web. Debur5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580  
Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

BE 10/08/24

W/O:		WORK ORDER CHANGES					
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8/10/08/24

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/08/24

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

7/11/10/08/25

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

W/O:		WORK ORDER CHANGES					
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Run Start  
StopSequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Powder Coating

0.00

190

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

0.00

① BL 10-8-26

ml 10 08 30 ①

W/O:		WORK ORDER CHANGES					
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts &amp; wearplates &amp; Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ Sikaflex-291 ☐ 115114 ☐ ☐

Sikaflex expire date: 11/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step &amp; Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ Sikaflex-291 ☐ 115114 ☐ ☐

Sikaflex expire date: 11/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 115028

ml 10 08 30 ①

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

0.00



QC

0.00

Quality Control

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

S106830



220

0.00



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD205-634-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

0.00

APP 65701

18/8/31

230

0.00



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

10/09/01

C210/9/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 1

Work Order ID: 60922

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube




Start Date: 7/26/2010

Required Date: 8/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD  
 IPP Rev. O 06.02.28 Added paperwork EC  
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2580-1  205 Skidtube bent detail		Manufactured	No			110	Each	6.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>4</div> <div></div> </div>													
<div> <div>57028</div> <div>1</div> <div></div> </div>													
<div> <div>59297</div> <div>1</div> <div></div> </div>													
<div> <div>60379</div> <div>2</div> <div></div> </div>													
<div> <div>ST046</div> <div>2</div> <div></div> </div>													
<div> <div>59913</div> <div>2</div> <div></div> </div>													
D2576-3  Step (maching detail)		Manufactured	No			140	Each	89.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>89</div> <div></div> </div>													
<div> <div>46661</div> <div>41</div> <div></div> </div>													
<div> <div>52215</div> <div>48</div> <div></div> </div>													
D2579  Crossbolt Spacer		Manufactured	No			140	Each	293.0000	20	20			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>293</div> <div></div> </div>													
<div> <div>57052</div> <div>5</div> <div></div> </div>													
<div> <div>57348</div> <div>4</div> <div></div> </div>													
<div> <div>58433</div> <div>2</div> <div></div> </div>													
<div> <div>59113</div> <div>282</div> <div></div> </div>													

B-61191 MB 10-08-19

BE 10-08-23

20 BE 10-08-23

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Parent Item Name: Replacement Skidtube

Start Date: 7/26/2010

Required Date: 8/17/2010

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

83.0000

1

1



Cap

Location

Loc Qty

Loc Code

FP6

1

56613

1

ST026

82

50513

1

50770

28

51539

2

53791

51

*mm 10.08.30*

AN3-SA

Purchased

No

200

Each

1,128.000

2

2



Bolt

Location

Loc Qty

Loc Code

ST350

1128

105057

628

115016

500

*mm 10.08.30*

AN960JD10L

NAS1149D0332J

Purchased

No

200

Each

3,025.000

2

2



Washer

Location

Loc Qty

Loc Code

ST348

3025

109632

4

110985

3021

*mm 10.08.30*

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Start Date: 7/26/2010

Required Date: 8/17/2010

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

950.0000

50

50



Insert

B#114723

Location

Loc Qty

Loc Code

FP 933

115079 933

ST282 17

113238 17

AN3C4A

Purchased

No

200

Each

995.0000

50

50



BOLT

Location

Loc Qty

Loc Code

ST350 995

114108 14

114416 12

114523 2

114941 967

AN960C10L

NAS1149C0332  
R

Purchased

No

200

Each

29.0000

50

50



washer

B#115000

Location

Loc Qty

Loc Code

ST245 29

107534 29

*mm 10.08.30*

*mm 10.08.30*

*mm 10.08.30*

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Required Date: 8/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-13 Manufactured No

200

Each

35.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

4

53461

4

FP012

31

59661

23

60209

8

*ml 10.08.30*

D3566-5 Manufactured No

200

Each

16.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP015

16

59158

16

*ml 10.08.30*

D3566-1 Manufactured No

200

Each

21.0000

2

2



Gasket

Location

Loc Qty

Loc Code

FP015

21

57715

2

59126

7

60202

12

*B# 60857*

*ml 10.08.30*

D3564-11 Manufactured No

200

Each

10.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP019

10

59941

10

*ml 10.08.30*

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Start Qty: 1.00

Required Qty: 1.00

D3564-13 Manufactured No

200

Each

19.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP17

19

59660

19

D3564-9 Manufactured No

200

Each

26.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

25

59201

12

60236

13

D3564-5 Manufactured No

200

Each

16.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

4

57525

1

58709

3

FP-19

11

59157

11

MM 10-08-30

MM 10-08-30

MM 10-08-30

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, July 26, 2010 3:47:51 PM

Page 6

Work Order ID: 60922



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 7/26/2010

Required Date: 8/17/2010

Start Qty: 1.00

Required Qty: 1.00

D2594-3      Manufactured      No

200      Each

419.0000

16

16



O-Ring, 205 Skidtube

Location

Loc Qty

Loc Code

FP	419	
55546	19	
58191	12	
59358	388	

*mm 10-08-30*

D2594-1      Manufactured      No

200      Each

451.0000

16

16



Plug, 205 Skidtube

Location

Loc Qty

Loc Code

FP	183	
42807	112	
55002	71	
FP14	268	
58434	79	
59110	189	

*mm 10-08-30*

Monday, July 26, 2010 3:47:51 PM

Shop Packet Print

Page 6

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**NOTE:** Date & initial all entries

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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WORK ORDER  
NO. *100922*

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**Dart Aerospace Ltd**

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RELEASED  
07-06-28

Diagram illustrating the underside of the D2576-3 step, showing the locations for grinding flush and the location ridge on the underside of the D2576.

Labels in the diagram include:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular component with a central hole and a rectangular slot. The drawing includes dimension lines and labels for various parts and materials:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to two locations on the outer edge of the component.
- SEAL WITH SIKAFLEX-241/-291**: Points to the area around the central hole.
- AN3-5A BOLT (1)**: Points to a bolt passing through the central hole.
- AN950D10L WASHER (1)**: Points to a washer on the bolt.
- (2 PLACES)**: Points to two locations on the outer edge of the component.
- D2855 CAP**: Points to the cap of the bolt.
- 0.40**: Dimension line indicating a distance of 0.40 units.

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50

DISTANCE TO AFT END OF D2598 WEB

38.0

190.0 (D2500-1)

17.375

26.000

34.188

91.500

57.313 (REF)

7 EQUAL SPACES

8.188 PITCH

#0.508 (TYP.) (40 PLACES)

REFER TO DETAIL A

**AFT FUSelage ASSEMBLY DETAIL**

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

D

P P P P P P P P

8

1.5

1.5

REFER TO DETAIL C

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN	J	DRAWN BY	
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DATE			
07.02.27			

DRAWING NO.	REV. D
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
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RELEASED  
07-16-28

Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular component, likely a cap or washer, showing dimensions and assembly instructions. The drawing includes the following callouts and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX-241/-291
- AN3-5A BOLT (1)
- AN960J10L WASHER (1) (2 PLACES)
- D2855 CAP
- SEE NOTE ii)
- 0.40

5

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)  
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

37.50  
DISTANCE TO AFT END  
OF D2596 WEB

3  
7

1.750 1.750

Ø0.508 (TYP.)  
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750  
17.375  
26.000  
34.188

57.313 (REF)  
7 EQUAL SPACES  
B.188 PITCH


38.0 91.500

190.0  
(D2500-1)

Figure 1 is an elevation view of the bridge deck showing the location of the 8 #508 bars. The diagram includes the following dimensions and labels:

- Overall deck width: 51.340
- Bar spacing: 5.338 (REF)
- Bar diameter: Ø0.508 (8 PLACES)
- Distance between hole and tangent point: 1.0
- Total length of the deck: 32.0 ± 1.0
- Other dimensions shown: 5.985, 1.4, 3.630, 5.915, 20.0, 11.5, 13.4, and 32.0 ± 1.0.

[illegible]

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	CHECKED	APPROVED		DRAWING NO.	REV. D
	DATE				SHEET 3 OF 3
				TITLE	SCALE
	07.02.27		205 SKIDTUBE ASSEMBLY	1:24	

W/O:		WORK ORDER CHANGES					
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NO. 232

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Bailey Elliott  
Job number: 59105  
Part number: D205-634-041  
Description: 205 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat. Duml. Date of Test Coupon 10.06.01  
Welder Bailey Elliott Date of Test Coupon 10.06.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld